

Work Order ID 55097

January 6, 2010 8:04:31 AM



Page 1

Item ID: D3687-1

Accept



Setup Start



Revision ID:

Item Name: MOUNT

Stop



Start Date: 1/06/10

Start Qty: 2.00

1/0



Cust Item ID:

Required Date: 1/14/10

Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3687

Rev B

100

0.00



Outsource1

Outsource process - Heat Treat

Memo

0.00

Send M174B3937X4750 For heat treating
to CONDITION H-900(to become M174PHH900B3937X4750)
FTU IN EXCESS OF 190 KSI
FTU IN EXCESS OF 170 KSI

CERTIFICATE IS REQUIRED

use B/N 112374

10.06.06

105

0.00



Outsource5

Outsource process - Machining

Memo

0.00

Issue P/O: 11034
Machine as per Dwg D3687
Possible Supplier: Globus Precision
Conformity sheet required

CD 10/02/06

2

Work Order ID 55097

January 6, 2010 8:04:31 AM

Page 2

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Item Name: MOUNT

Start Date: 1/06/10

Start Qty: 2.00

Required Date: 1/14/10

Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

Ensure certificate of conformity is attached

P 10/07/28 (C)

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

*2) Siobhán**(+)*

124

0.00



Purchasing

Memo

0.00

Purchasing

Issue P/O FOR LIQUID PENETRATION

P/O #: *11290*

Certificate of conformity is required

P 10-2-01 (1)

Work Order ID 55097

January 6, 2010 8:04:32 AM



Page 3

Item ID: D3687-1

Accept



Setup Start



Revision ID:

Stop



Item Name: MOUNT

Start Date: 1/06/10

Start Qty: 2.00



Cust Item ID:

Required Date: 1/14/10

Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

125



Packaging

Receive & Inspect for Damage & Mat'l Certs

0.00

Memo

0.00

ENSURE NDT RESULT IS ATTACH

Packaging

P 10/2/5 (1)

126



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

*2) 8/10/02/00**(40)*

130



Packaging

Packaging

Identify as per dwg & Stock Location: _____

0.00

Memo

0.00

10-2-8 (12) S

Work Order ID 55097

January 6, 2010 8:04:32 AM



Page 4

Item ID: D3687-1

Accept



Setup Start



Revision ID:

Item Name: MOUNT

Stop



Start Date: 1/06/10 Start Qty: 2.00



Cust Item ID:

Required Date: 1/14/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/08
MF
10-2-08

Picklist Print

January 6, 2010 8:04:30 AM

Page 1

Work Order ID: 55097

Parent Item: D3687-1

Parent Item Name: MOUNT



Comments:

Start Date: 1/06/10

Required Date: 1/14/10

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M174PH- H900B3.937X4.750		Purchased	No			100	f	17.9277	0.6667			
												
17-4SS Bar H900-3.937x4.750												

m112374 c20101104

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

17.9277

110875

2.9

111100

0.1

112374

14.9277

D3687-1P

Purchased

No

105

Each

0.0000

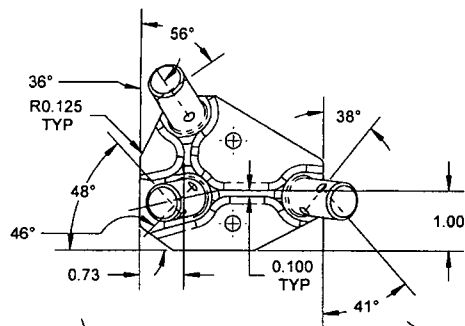
1/2.0000



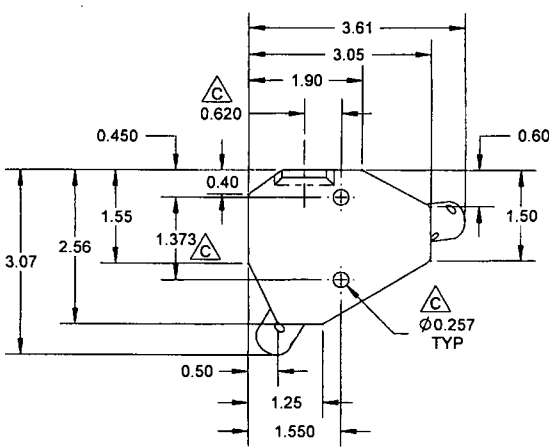
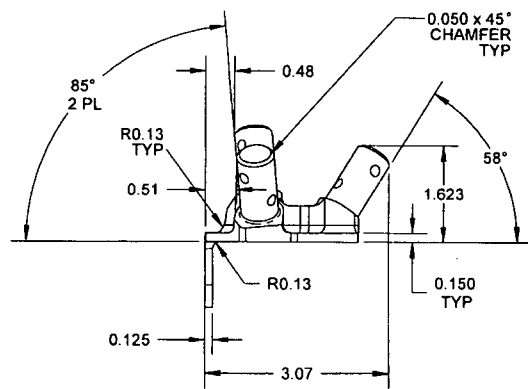
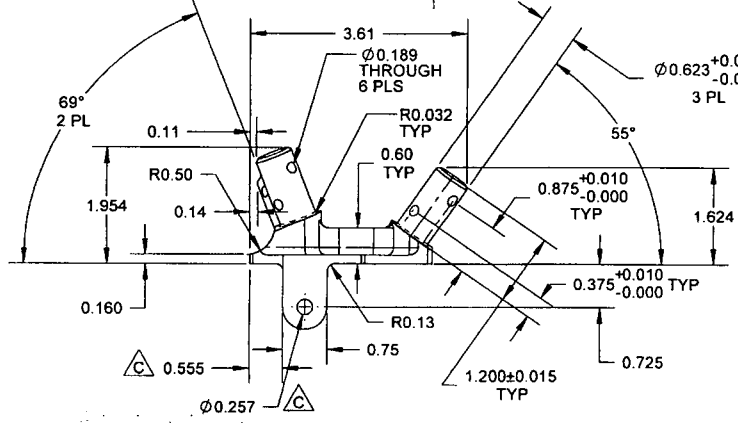
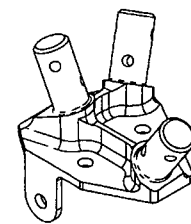
MOUNT



MF 10-02-08



WLO 55097



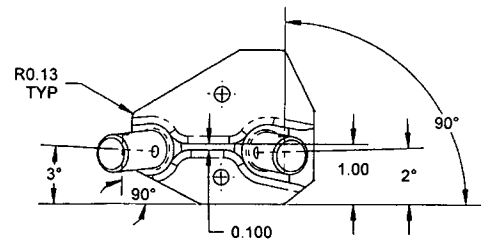
D3687-1 MOUNT

- NOTES:
- 1) MATERIAL: 17-4PH SS BAR PER AMS 5643, H-900 CONDITION
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.81 lb
 - 8) LPI PER QSI 038 4.1.1 (ASTM E1417 LEVEL 2)

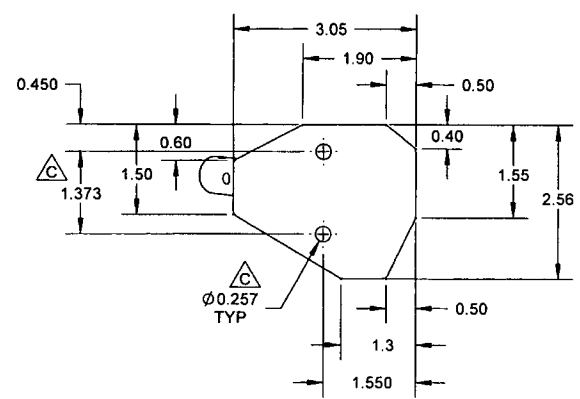
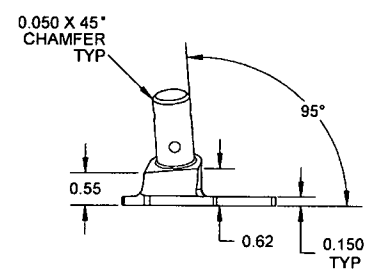
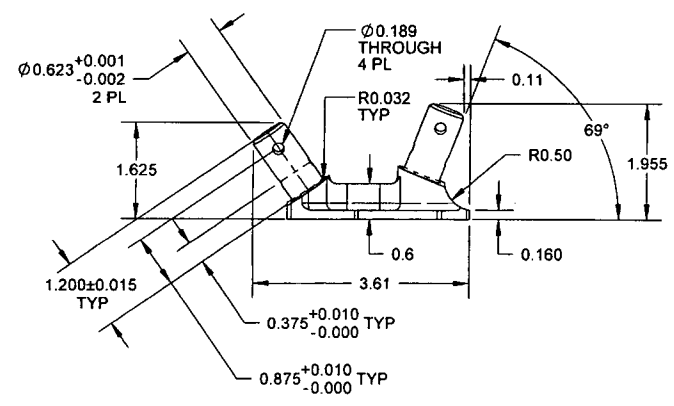
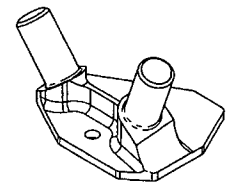
RELEASED
2009-09-22

C	0.555 WAS 0.50 (ZN B8-1); 1.373 WAS 1.375 (ZN A8-1, A8-2); ADD 0.620 (ZN B7-1) PER NCR09-084; UPDATE NOTE 8 TO REF QSI (ZN A6-1, B3-2); Ø0.257 WAS Ø0.250 (ZN A6-1, B7-1, B7-2)	RF	09.08.26
B	CHANGE TO 17-4PH H-900 (ZN A6-1 & B3-2); R0.032 WAS R0.015 (ZN C7-1 & C7-2); REFORMATTED TO CURRENT DWG STANDARDS	RF	08.11.24
A	NEW ISSUE	RF	08.03.12
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3687 REV. C SHEET 1 OF 2 TITLE MOUNT SCALE NTS	
DRAWN	RF		
CHECKED	<i>WLO</i>		
MFG. APPR.	<i>WLO</i>		
APPROVED	<i>WLO</i>		
DE APPR.	<i>WLO</i>		
DATE	09.08.26	COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1



Wb 55097



D3687-3 MOUNT

- NOTES:
- 1) MATERIAL: 17-4PH SS BAR PER AMS 5643, H-900 CONDITION
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.64 lb
 - 8) LPI PER QSI 038 4.1.1 (ASTM E1417 LEVEL 2)

RELEASED
2009-08-22
MP

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JD</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>JD</i>	D3687	SHEET 2 OF 2
APPROVED	<i>JD</i>	TITLE	SCALE
DE APPR.	<i>JD</i>	MOUNT	NTS
DATE	09.08.26	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PO REPRINT

Purchase Order ID PO11034

Purchase Order Date 1/06/10

PO Print Date 1/25/10

Page Number 1 of 1

Order From :

VC-GLO001

GLOBUS PRECISION INC.
36 COLONNADE RD. N.
NEPEAN, ON K2E 7J6
CA

FAXED
1-800-251-2511

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	613 226 1579	Requisition Nbr	
Vendor Fax	613 226 1719	Tax Resale Nbr	10127-2607
Vendor Account Nbr		Terms	Net 30
		Currency	CAD
		FOB	

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D3687-1P	MOUNT	1/14/10 Yes	✓ 1.00 Each	Purolator ground	\$1,161.5000	\$1,161.50

Special Inst: MACHINE AS PER DWG D3687
REV. C
B55097
MATERIAL SUPPLIED BY DART
M17-4PHH900B3.937X4.750
M112374

11 1/14/10

PO Total: \$1,161.50

Change Nbr: 5

Change Date: 1/25/10

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable



Invoice

36 Colonnade Road N.
Ottawa, Ontario K2E 7J6
Tel: (613) 226-1579
Fax: (613) 226-1719

DATE	INVOICE NO
1/26/2010	17875

BILL TO	SHIP TO
Dart Aerospace 1270 Aberdeen Street Hawksbury, Ontario K6A 1K7	Main Finished Goods Location Dart Aerospace 1270 Aberdeen Street Hawksbury, Ontario K6A 1K7

P.O. NO.	TERMS	SHIP DATE	SHIPPED VIA	JOB NO.	FOB
11034	Net 30 Days	1/26/2010	FedEx	63	Globus

QTY	DESCRIPTION
1	D3687-1 Mount Business Number: 102122058 S 10/6/12

WHITE = Original
BLUE = C of C
YELLOW = Packing Slip

Carrying Charge - 2% per Month -24% per Annum
on Overdue Accounts



Manufactured by Conbraco Ind. Inc.

P. O. Box 125 Pageland S.C. 29728

Phone: [843] 672-6161

Fax: [843] 672-1566

Certificate of Compliance

Customer: **FLO-CONTROL INC**

Date: **1/21/2010**

PO #: **63036**

Qty: **6**

Oil Order #: **C 554484**

Part #: **7610132A**

Description: **BV,1/4"NPT,SS,SS TEE HNDL**

This is to certify that the above materials comply with the requirements of the applicable purchase order and the codes and ratings shown in our published catalog of the "Apollo" valves, manufactured by Conbraco Industries Inc. or other specification as noted above. All products are manufactured, tested and assembled in the United States of America. All products have met or exceed the inspection process.

Respectfully,

A handwritten signature in cursive script that reads "John F. Higdon".

John F. Higdon
Corporate Quality Assurance Manager

PQA049

FLO-CONTROL, INC.
80 CENTER RD
CARTERSVILLE, GA 30121
PH: 770-382-0006, FAX: 770-382-0161
800-282-1870

APOLLO - CHECK-ALL - DURAVALVE - HERION - KOBOLD
INSTRUMENTS - MARSH BELLOFRAM - WESTLOCK CONTROLS

FAX MESSAGE

DATE: 1/29/10

TO: Chantal

CO: Dart Aerospace

FAX #:

FROM: Ana Flynn

RE: PO# P011175

NUMBER OF PAGES, INCLUDING THIS COVER PAGE: 2

Chantal

Here is the cert. of Compliance
for valves

Thanks

Ana



LIQUID PENETRANT TEST REPORT

P- 15316

CLIENT DAI AEROSPACE DATE FEB 1-2010 PAGE 1 OF 1
ATTENTION LINDA ACUREN JOB No. 188-10-0650 TIME AM ☒ PM ☐
ADDRESS 1270 ABERDEEN ST. POWO No. ---
HAWKESBURY ON. WORK LOCATION HAWKESBURY -
K6H 1K7 ACCEPTANCE STD. ASTM 1417 REV./DATE 2007
PROJECT F.P.I. ON CROSS TUBES
ITEM(S) EXAMINED (12) SLEEVE'S (6)

JOB DESCRIPTION STAINLESS STEEL PROCEDURE NO. LT4002 REV./DATE --- TECHNIQUE NO. LT4042 REV./DATE ---
PART NO. --- MATERIAL ALUMINE ALUMINUM THICKNESS ---
SCOPE WET FLUORESCENT LIQUID PENETRANT INSPECTION
CARRIED OUT 100% EXTERNAL

TEST DETAILS
METHOD ☒ FLUORESCENT ☐ VISIBLE
FAMILY BRAND MAGNAFLUX
PENETRANT 2L 6F MINIMUM DWELL TIME 45 MIN. ☒ WATER WASH ☐ SOLVENT REMOVABLE ☐ POST EMULSIFIED
PENETRANT REMOVER H2O MINIMUM DRY TIME >10 MIN. BLACK LIGHT S/N 16459 ☒ OUTPUT > 1000 μ W/CM² ☐ AMBIENT < 2 fc
DEVELOPER SKD 52 MINIMUM DWELL TIME 10 MIN. LIGHTING EQUIP. ☐ FLASHLIGHT ☐ TROUBLELIGHT ☐ OUTPUT > 100 fc @ SURFACE
DEVELOPER TYPE ☒ NON AQUEOUS ☐ AQUEOUS ☐ DRY OTHER LABNO
LIGHT METER S/N 1098866 CAL DUE DATE MAY 7-2010
TEST SURFACE
SURFACE CONDITION ☐ AS GROUND ☐ AS WELDED ☐ MACHINED ☐ SHOT BLASTED ☐ CLEAN BARE METAL
SURFACE TEMPERATURE ☐ < -4°C/ 20°F ☐ -4°C/ 20°F TO 10°C/ 50°F ☐ 10°C/ 50°F TO 52°C/ 125°F ☐ > 52°C/ 125°F
RESULTS- ☐ METRIC ☐ IMPERIAL

12 SLEEVE'S - W.O. 55638 ✓
1 CROSS TUBE - W.O. 55132 ✓
1 CROSS TUBE - W.O. 55133 ✓
1 CROSS TUBE - W.O. 55406 ✓
1 CROSS TUBE - W.O. 55404 ✓
20 COLLECTIVE BELL CRANK - W.O. 53635 ✓
1 MOUNT - W.O. 55097 ✓
1 CROSS TUBE - W.O. 55433 ✓
1 CROSS TUBE - W.O. 55434 ✓

ALL ITEMS EXAMINED ON THIS
REPORT WERE FOUND ACCEPTABLE
TO THIS STANDARD.

S
10/02/08

Scope of Services
The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.
Standard of Care
In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES
CLIENT REPRESENTATIVE MATTHEW MURDOCH DTR # E-27697
TECHNICIAN (SIGNATURE): Mike JENSTEN SIGNATURE Matthew Murdoch
NAME (PRINT): Mike JENSTEN REPORT REVIEWED BY: ---
CGSB LEVEL II SNT LEVEL II CGSB LEVEL --- SNT LEVEL ---
CGSB REG. No. 6606 CGSB REG. No. ---

WHITE - CLIENT COPY

CANARY - OFFICE COPY

PINK - TECHNICIAN COPY

GOLD - OFFICE COPY